



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7702
Job Sheet 202748



Part No: 647.7702

Job Qty: 8 pcs **DAS**

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Due Date: 12/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
120	Large Fab - Welded Assy-1	8 pcs	12/13/19		0.00	3.29	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	MV Dec 23/19
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
							Large Fab - 12	
130	QC 9	8 pcs	12/13/19		0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	CL
							QC 9 - 9	
140	QC 5	8 pcs	12/13/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	



Container No: S243383



Part No: 647.7702

Job No: 202748

Serial No/Batch: S243383

Revision: Rev A2

Sector:

Dart Aeros
1270 Aberdeen St
Hawkesbury,
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	12
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150	Outsource - 3 - Cadplate	8 pcs	12/13/19	GRO002-VC	7 JAN 2020-01-02
160	Packaging 2-1 - Receive - B4B	8 pcs	12/13/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
170	QC 6	8 pcs	12/13/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
180	Spray Paint - 2 - B4B	8 pcs	12/13/19	0.00 0.62	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
190	QC 14	8 pcs	12/13/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51

			QC 14 - 58	
			QC 14 - 59	
			QC 14 - 9	
			QC 14 - 68	
			QC 14 - 40	DAS 40 JAN 17 2020
			QC 14 - 19	9-89
			QC 14 - 43	
			QC 14 - 24	
			QC 14 - 61	
			QC 14 - 81	
200	Packaging 3-1 - Stock - B4B	12/13/19	0.00 0.00	Packaging 3 - 1 - B4B
	12 pcs			Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
210	QC 21 - SA	12/13/19	0.00 0.00	QC 21 - SA - 21
	12 pcs			QC 21 - SA - 70
				QC 21 - SA - 53
				DAS 21 JAN 20 2020

Part Op 120 - (Weld per dwg A/R 4130 rod Batch MI27925) 1- ASSEMBLE AND WELD AS PER DWG 0 ***IMPORTANT

Descriptions: DIMENSION IS 11.60" ***

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O : 45378 Group Altech CAD

PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - INSPECT USING GO/NO GO GAUGE

180 - (Spray Paint / NDT Room) PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER

BATCH: 5195271

190 - (QC14- Inspect Spray Paint)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release) PLEASE NOTE ON PO: Apply only Class 3 Cad to the threaded are only CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7711	Strut Tube	8 pcs (1 ea)	120-Large Fab - Welded Assy-1	5107258
647.7712	Strut Tube	8 pcs (1 ea)	120-Large Fab - Welded Assy-1	5222553 / 15 5240366
647.7713	Strut Thread	8 pcs (1 ea)	120-Large Fab - Welded Assy-1	5242195

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7711	8	24	0
	647.7712	8	45	0
	647.7713	8	38	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045378



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045378

PO Date: 12/12/19

Due Date: 1/10/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-01-06

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204139	647.7701	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material - 4130; RC33 - NO baking required note: cad plate should not be too thick around tread	Firmed X10	-	1/10/20	10 pcs	0 pcs	10 pcs	\$13.75/pcs	\$137.50
									JAN 15 2020			
2	202748	647.7702	647.7700 Rev A2	Strut Assembly : Various STC's Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material - 4130; RC 33; NO baking required note: cad plate should not be too thick around tread	Firmed X12	-	1/10/20	12 pcs	0 pcs	12 pcs	\$15.89/pcs	\$190.68
									JAN 15 2020			

DAS
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9-19



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Canada

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PURCHASE ORDER

POHB045378



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	203278	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material - 4130; RC 33 - NO baking required ****NOTE: limit cad plating on thread to 0.003" or less****	Firmed <i>X12-</i>	-	1/10/20	12 pcs	0 pcs	12 pcs	\$14.75/pcs	\$177.00
											Grand Total:	
											\$505.18	

JAN 15 2020

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Kimberley

Plex 1/6/20 8:43 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(025201-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

025201 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
14-Jan-2020	Jigar Patel		POHB045378					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.7701 Rev.A2	647.7701 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER QQ-P-416F TYPE - 2, CLASS - 1 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD	CADMIUM CH	10	10	0	0	0
2	647.7702 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005" (CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD)	CADMIUM CH	12	12	0	0	0
3	647.7703 Rev.	647.7703 01 -CAD YELLOW 0.0005 THICK OR LESS CAD PLATE IAW QQ-P-416F CLASS I TYPEII CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD MATERIAL STEEL LIMITE ON THREAD 0.003 THICK OR LESS	CADMIUM CH	12	12	0	0	0

RECEIVED

JAN 14 2020

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.